

Date: Friday, 02/05/2008 11:55:52 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	CABIN DOOR ROLLER KIT, LH		
Job Number	39006			Part Number	D412698011		
Estimate Number	10276			Drawing Number	IIN D412-698 REV D		
P.O. Number	:			Project Number	N/A		
This Issue	02/05/2008 S.O. No. :			Drawing Revision	D		
Prsht Rev.	NC			Material	:		
First Issue	02/05/2008 Type : MACHINED PARTS			Due Date	20/05/2008 Qty: 4 Um: Each		
Previous Run	38979						
Written By	:						
Checked & Approved By	<u>JLD 08.5.06</u>						
Comment	Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS Est Rev:D 08-01-28 change to rev D ECN 1104 DD						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-698-011 CHG003	<u>S 08/05/06</u> <u>JLD 08.5.06</u>
2.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
3.0	D3121141	Bracket Assembly	
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 3 D3121-141 Bracket Assembly 13 39301	<u>RL</u>
4.0	D3121143	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 1 D3121-143 Bracket Assembly 14 39014	<u>RL</u>
5.0	D3137043	Bracket Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 1 D3137043 Bracket Assembly 14 29725	<u>RL</u> 14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 02/05/2008 11:55:52 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, LH

Job Number: 39006

Part Number: D412698011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	D3137-043	Bracket Assembly
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6.0	D3183043	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

1 D3183-043 Bracket Assembly

37672

2X New Batch
Not in comp yet

B38982 x2

7.0	D31991	Bracket
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Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

9 D3199-1 Bracket

39049 35 X

344510 1X

8.0	D32021	Cover
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

Batch

1 D3202-1 Cover

38440

10/05/27 Q

9.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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INSPECT 100% KITS FOR COMPLETENESS

S 08/05/28 23(X4)

Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP.D412-698-011

Location: Rev TS

PS 08/05/28 (R4)
08/05/29 (F)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Part Number	Description
X							D412-698-011	CABIN DOOR ROLLER KIT, LH
	X						D412-698-012	CABIN DOOR ROLLER KIT, RH
		X					D412-698-013	DOOR HANDLE KIT
			X				D412-698-015	DOOR SUPPORT KIT
				X			D412-698-017	REPLACEMENT DOOR TRACK KIT
					X		D412-698-019	BEARING OVERHAUL KIT
						X	D412-698-021	REPLACEMENT SHIM KIT
					7		D3121-21	BOLT
					5		D3121-241	BEARING ASSEMBLY
3	3						D3121-141	BRACKET ASSEMBLY
1							D3121-143	BRACKET ASSEMBLY
	1						D3121-144	BRACKET ASSEMBLY
					1		D3137-3	GUIDE
					1		D3137-5	WASHER
1	1						D3137-043	BRACKET ASSEMBLY
					2		D3183-045	BEARING ASSEMBLY
1							D3183-043	BRACKET ASSEMBLY
	1						D3183-044	BRACKET ASSEMBLY
9	9				9		D3199-1	BRACKET
1	1				1		D3202-1	COVER
					4		D3203-1	HANDLE
					1		D3220-041	DOUBLER
					1		D3220-042	DOUBLER
					2		D3220-3	DOUBLER
					2		D3200-1	DOOR POST BLOCK
					2		D3200-3	DOOR WEDGE
					2		D3201-1	DOUBLER
					1		D3201-3	ANGLE
					1		D3201-4	ANGLE
					3		D3238-1	SHIM
					1		D3238-3	SHIM
					2		D3238-5	SHIM
					6		D3238-11	SHIM
					2		D3238-13	SHIM
					4		D3238-15	SHIM
				12			AN960JD10L	WASHER
	8						AN960JD416L	WASHER
				12			MS21042L3	NUT (OR MS21042-3)
	8						MS21042L4	NUT (OR MS21042-4)
				16			MS24694-S98	SCREW
					1		MS24694-S101	SCREW
				12			MS24693-S277	SCREW

(CONTINUED ON PAGE 15)

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

NOTICE

WITHOUT NOTICE

WORK ORDER

NO 37002